

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016902**Date Inspected:** 17-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder(OBG)	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 9BW, 9DW, 9EW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00494 to perform final tension verification for Retrofit Plate at Cross Beam & Counter Weight side between Panel Points (PP) 74,PP80, PP83 for Segment 9BW, 9DW, 9EW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M24 x 60 DHGM240027 and final torque required was 572 N-m.

Bolt sizes used were M24 x 70 DHGM240075 and final torque required was 680 N-m.

Bolt sizes used were M24 x 75 DHGM240020 and final torque required was 600 N-m.

Bolt sizes used were M24 x 85 DHGM240019 and final torque required was 550 N-m.

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Bolt sizes used were M24 x 90 DHGM220076 and final torque required was 474 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676.

Segment # 9BW, 9DW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00494 to perform final tension verification for WT Stiffener Clip at Cross Beam & Counter Weight side between Panel Points (PP) 74, PP75, PP81, PP82 for Segment 9BW, 9DW, . Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 80 DHGM240012 and final torque required was 427 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676.

Segment # 9DE

This Quality Assurance (QA) received ZPMC inspection notification sheet 00494 to perform final tension verification for Cable Tray at Cross Beam side between Panel Points (PP) 80 for Segment 9DE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were 3/4 x 2 DHG60631 and final torque required was 346 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676.

Segment # 9W

This Quality Assurance (QA) received ZPMC inspection notification sheet 00494 to perform Visual Testing (VT) for Catwalk Railing Lift # 9W

Bay # 1

This QA received ZPMC inspection notification sheet 06690 to perform dimensional inspection of traveler rails identified as 20TR1-048. Dimensional inspections performed on each of these traveler rails, overall length, Rail sweep, Thickness at typical Section, flange width at typical Section, Depth Typical Section. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurement Survey: Traveler Rails and submitted to CT QA lead for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
